

Work Order ID 84884

84884

Page 1

May-29-12 1:02:19 PM

Item ID: D209-669-013

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Skidtube LH

Stop ***NS2***

Start Date: 29/05/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: ML5

Date: 12/05/30 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D209-669-013	Rev B
--------------	-------

DSI 9450	Rev A
----------	-------

100

100

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per PPP d209-669-013 CHG003

0.00

0.00

110

110

Packaging

Packaging

Pick Kit

Memo

0.00

0.00

84896

DAS 16
12/6/12
boy
per ECN 12-599

[Signature] ML5 12-7-11

[Signature]

1x

[Signature]
12-7-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84884

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Page 2

May-29-12 1:02:19 PM

Item ID: D209-669-013

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube LH

Start Date: 29/05/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

130

Packaging

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD209-669-013
Location: SHIP

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

Handwritten signature

12/17/18

ME 12-07-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

May-29-12 1:02:22 PM

Page 1

Work Order ID: 84884

84884

Parent Item: D209-669-013

D209-669-013

Parent Item Name: Skidtube LH

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

New IPP 08.02.13 LL, verified by:DD

IPP Rev:B 08-05-20 chg QTY of D2570 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D209-669-043

Manufactured

No

110

Each

2.0000

1

1

D209-669-043

Replacement Skidtube

**

84896

Location

Loc Qty

Loc Code

Mezz

2

39205

1

39206

1

D2917-1

Manufactured

No

110

Each

0.0000

2

2

D2917-1

Saddle LH

**

384937

D2918-1

Manufactured

No

110

Each

3.0000

2

2

D2918-1

Saddle LH

**

384938

Location

Loc Qty

Loc Code

ST424

3

54467

3

AN4-51A

Purchased

No

110

Each

302.0000

8

8

AN4-51A

Bolt

**

5012-7-11

Location

Loc Qty

Loc Code

362

200

121181

200

ST361

102

119798

30

121584

72

8x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

May-29-12 1:02:23 PM

Page 2

Work Order ID: 84884

84884

Parent Item: D209-669-013

D209-669-013

Parent Item Name: Skidtube LH

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

D2570

Manufactured No

110 Each

711.0000 24 24

D2570

Bushing

**

B85411 Sp.

Location

Loc Qty

Loc Code

ST011

711

72960

41

78586

9

79493

12

81956

24

81957

400

82874

225

MS21042L4

Purchased No

110 Each

4,095.000 24 24

MS21042L 4

Nut

**

Sp.

Location

Loc Qty

Loc Code

ST300

4095

119075

125

121011

713

121444

2957

121652

300

AN5-36A

Purchased No

110 Each

184.0000 4 4

AN5-36A

Bolt

**

Sp.

Location

Loc Qty

Loc Code

340

134

121181

34

121652

100

ST340

50

121708

50

AN960JD516

NAS1149D0563J Purchased

No

110 Each

0.0000 8 8

AN960JD516

Washer

**

m119546 Sp. 12-7-11

May-29-12 1:02:23 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

May-29-12 1:02:23 PM

Page 3

Work Order ID: 84884

84884

Parent Item: D209-669-013

D209-669-013

Parent Item Name: Skidtube LH

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased

No

110

Each

1,447.000

4

4

MS21042L5

Nut

**

Location

Loc Qty

Loc Code

300

500

121652

500

ST300

947

108827

8

116105

5

116548

43

117611

18

119109

865

17651

8

AN4-7A

Purchased

No

110

Each

124.0000

16

16

AN4-7A

Bolt

**

Location

Loc Qty

Loc Code

ST356

124

117514

24

120770

100

AN960JD416

NAS1149D0463J

Purchased

No

110

Each

30.0000

32

32

AN960JD416

Washer

**

Location

Loc Qty

Loc Code

ST351

30

116289

10

119097

20

May-29-12 1:02:23 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

May-29-12 1:02:23 PM

Page 4

Work Order ID: 84884

84884

Parent Item: D209-669-013

D209-669-013

Parent Item Name: Skidtube LH

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

D2929

Manufactured No

110 Each

86.0000

2

2

D2929

Spacer

**

SP

SP

Location

Loc Qty

Loc Code

ST021

86

53564

86

2x

D2930

Manufactured No

110 Each

102.0000

2

2

D2930

Spacer

**

SP

SP

Location

Loc Qty

Loc Code

ST021

102

53563

102

2x

D3405-041

Manufactured No

110 Each

6.0000

1

1

D3405-041

Lug Assembly

**

12-7-17 SP

B85450

Location

Loc Qty

Loc Code

ST478

6

62227

2

77000

2

82031

1

82032

1

AN4C47A

Purchased No

110 Each

48.0000

4

4

AN4C47A

Bolt

**

m122204 SP

SP

12-7-11

Location

Loc Qty

Loc Code

ST361

48

118451

6

119798

2

121009

22

121585

18

May-29-12 1:02:23 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

May-29-12 1:02:23 PM

Page 5

Work Order ID: 84884

Parent Item: D209-669-013

Parent Item Name: Skidtube LH

84884

D209-669-013

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

MS21043-4

Purchased

No

110

Each

1,346.000

5

5

MS21043-4

Nut

**

Sp. Sp

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

1306

119546

147

121162

659

121652

500

5x

5x

D3405-043

Manufactured

No

110

Each

2.0000

1

D3405-043

Lug Assembly

**

B85099Sp

Location

Loc Qty

Loc Code

ST478

2

82038

2

D3407-041

Manufactured

No

110

Each

27.0000

1

1

D3407-041

Tow Ring

**

B8544

12-7-16 Sp

Location

Loc Qty

Loc Code

ST463

27

82067

6

82068

19

82108

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

May-29-12 1:02:23 PM

Page 6

Work Order ID: 84884

84884

Parent Item: D209-669-013

D209-669-013

Parent Item Name: Skidtube LH

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3456-1

Manufactured No

110

Each

156.0000

1

1

SP

SP

D3456-1

Washer

Location

Loc Qty

Loc Code

FG

7

25701

7

ST044

149

80252

1

81876

48

83584

100

1X

SP

D3417-5

Manufactured No

110

Each

78.0000

2

2

B84943 SP

12-7-11

D3417-5

Washer

Location

Loc Qty

Loc Code

ST042

78

78842

28

83318

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D209-669 REV. B

INSTRUCTIONS:

- 1) FOR D209-669-011/-012/-013/-014 SKID TUBES @ CHANGE 003 AND SUBSEQUENT, MODIFY THE FOLLOWING:
 - a) REPLACE THE D2968-041 TOW RING WITH THE D3407-041 TOW RING ASSEMBLY.
 - b) REPLACE THE D2736-1 AND D2736-3 GHW LUGS WITH THE D3405-041 AND D3405-043 LUG ASSEMBLIES.
 - c) AMEND THE PARTS LIST IN SECTION 5.0 OF INSTALLATION INSTRUCTIONS IIN-D209-669 REV. B AS SHOWN ON PAGE 2 OF THIS DSI.

NOTE: ALL INSTALLATION FASTENERS FOR THE ABOVE CHANGES HAVE BEEN UPDATED. SEE THE AMENDED PARTS LIST ON PAGE 2 FOR DETAILS.

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 84884 M15
 12/05/30

A	NEW ISSUE	AJS	09.02.24
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9450	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE INSTALLATIONS	NTS
DATE	09.02.24		
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

• **NOTE:** Date & initial all entries

5.0 PARTS LIST

ITEM	QTY -011	QTY -012	QTY -013	QTY -014	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
	X						D209-669-011	SKIDTUBE INSTALLATION, LH (AH-1W/J)
		X					D209-669-012	SKIDTUBE INSTALLATION, RH (AH-1W/J)
			X				D209-669-013	SKIDTUBE INSTALLATION, LH (AH-1P/F/S)
				X			D209-669-014	SKIDTUBE INSTALLATION, RH (AH-1P/F/S)
	1	1			X		D209-669-041	REPLACEMENT SKIDTUBE (AH-1W/J)
			1	1		X	D209-669-043	REPLACEMENT SKIDTUBE (AH-1P/F/S)

IS:

50	4	4	1	1			D3405-041	LUG ASSEMBLY
51	8	8	4	4			AN4C47A	BOLT
52	16	16	8	8			D2570	BUSHING
53	8	8	4	4			MS21043-4	NUT
54			1	1			D3405-043	LUG ASSEMBLY
60	1	1	1	1			D3407-041	TOW RING ASSEMBLY
61	1	1	1	1			D3456-1	WASHER
62	1	1	1	1			MS21043-4	NUT
63	2	2	2	2			D3417-5	WASHER

WAS:

50	4	4	1	1			D2736-1	GHW LUG
51	8	8	4	4			AN4-46A	BOLT
52	16	16	8	8			D2570	BUSHING
53	8	8	4	4			MS21042L4	NUT (OR MS21042-4)
54			1	1			D2736-3	GHW LUG
60	1	1	1	1			D2968-041	TOW RING
61	1	1	1	1			AN970-4	WASHER
62	1	1	1	1			MS21042L4	NUT (OR MS21042-4)

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9450	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE INSTALLATIONS	NTS
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

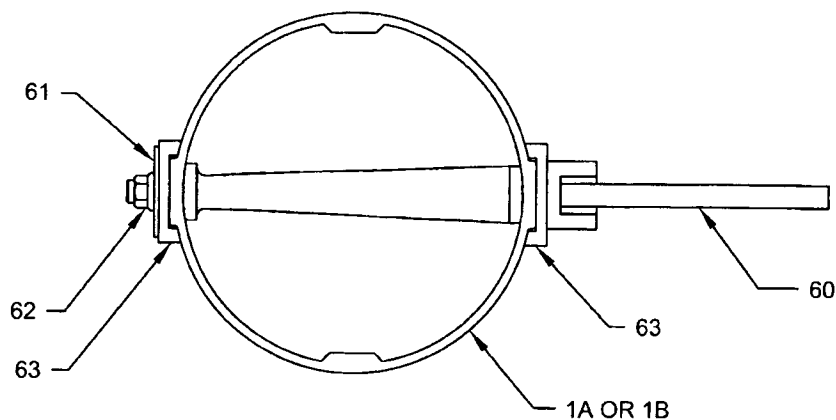
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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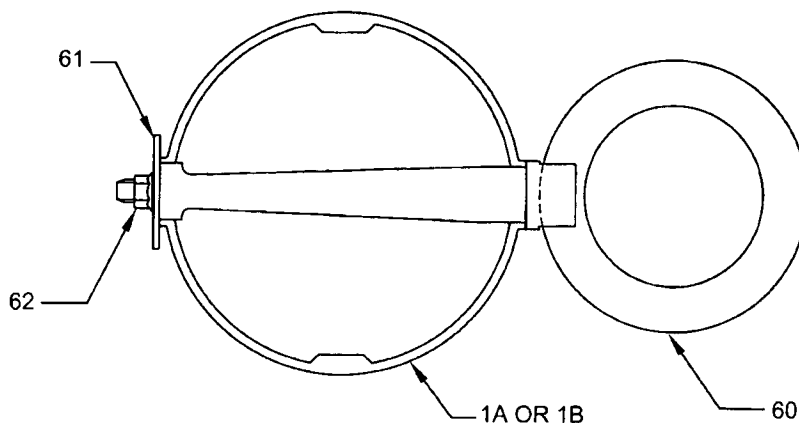
• **NOTE:** Date & initial all entries

INSTALL TOW RING ASSEMBLY AS SHOWN BELOW (REFER TO SECTION F-F OF IIN-D209-669 REV. B.

IS:



WAS:



NO PICTORIAL CHANGE REQUIRED FOR GROUND HANDLING WHEEL LUG CHANGES.

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9450	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE INSTALLATIONS	NTS
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24882

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